

Date: Tuesday, 8/21/2007 1:59:08 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CYCLIC STICK
Job Number	: 34117		
Estimate Number	: 12832		
P.O. Number	: N/A	Part Number	: G10202
This Issue	: 8/21/2007 S.O. No. : N/A	Drawing Number	: G10202 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	: 32074	Material	: N/A
Written By	:	Due Date	: 9/15/2007
Checked & Approved By	: <u>07.08.21</u>	Qty:	5 Um: Each
Comment	: Est Rev A New Issue 07-04-16 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304TR1125W065	304 RD Tube 1.125 x .065w
-----	----------------	---------------------------



Comment: Qty.: 2.6250 f(s)/Unit Total : 13.1250 f(s)

304 RD Tube 1.125 x .065w

Batch: 1104556

07.09.04 (3)

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

Form ,Cut all 3 parts of assembly as per Dwg G10202. & DT8940

only

07.09.04

3.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

07.09.05 (3)

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1

Weld assembly as per dwg G10202.

A/R SS Rod Batch: 1104721

07.09.12 (3)

5.0	DO NOT USE	WELD INSPECTION
-----	------------	-----------------



Comment: WELD INSPECTION

07.09.12 (3)

6.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
-----	---------------	------------------------------



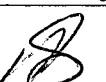

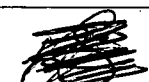

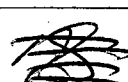
Comment: CONVENTIONAL MILLING MACHINE

Drill as per Dwg.

07.09.18 (3)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07/02/12	4.1	grind weld permanent change			3	07/07/15	07/07/17	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: ED Date: 07/07/17
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/02/12	2	2 scrap Bent wrong. P.C. Hammer error	 Q9242	destroy	 07/02/12	 CP 07/02/05	 Q9242	 CP 07/02/05

NOTE: Date & initial all entries

Date: Tuesday, 8/21/2007 1:59:08 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CYCLIC STICK

Job Number: 34117

Part Number: G10202

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 7/11/8 (X3)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

En 7/18/18 (3)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

1207109

Job Completion



U 7/19/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

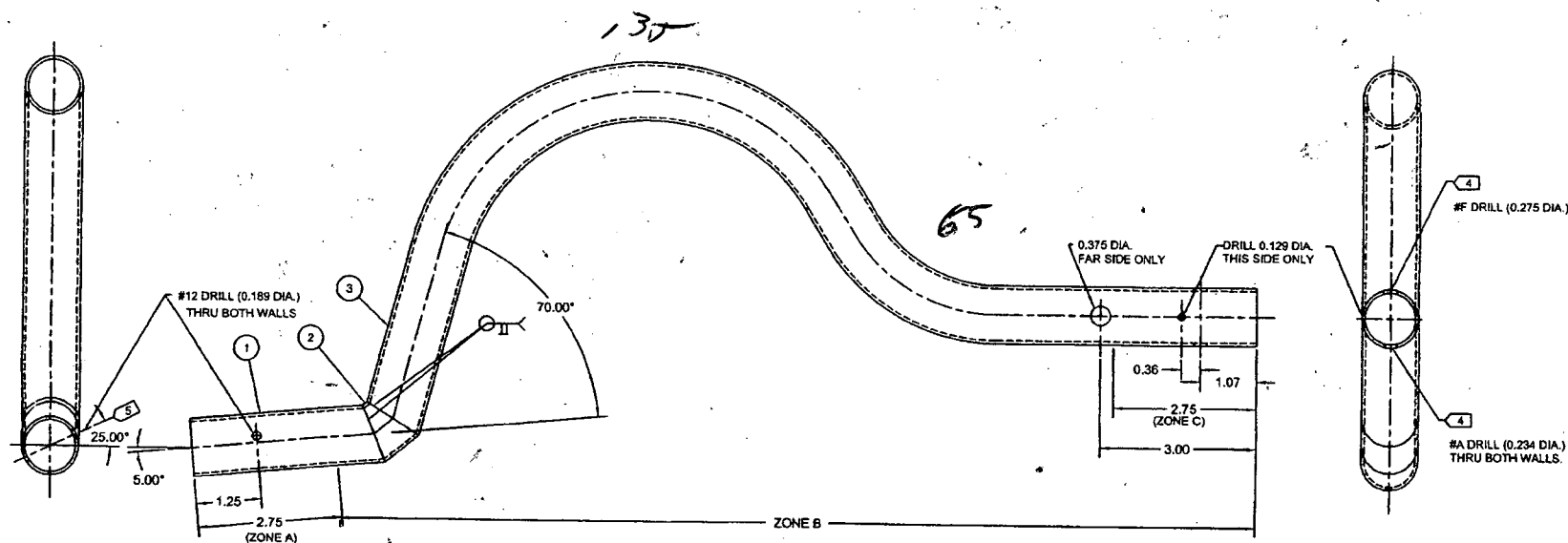
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

MICHA SSK

REVISIONS		
REV	DESCRIPTION	APPROVED
A	REDRAWN IN CAD	5/30/03 CLB



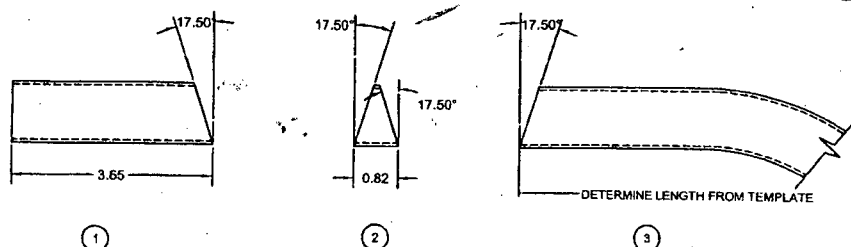
DETAIL -1

ZONE	TOLERANCE
A	±.050
B	±.300
C	±.050

NOTES: 1 DEBURR ALL SHARP EDGES.

- ④ DRILL 0.234 DIA. THRU BOTH WALLS. THEN DRILL 0.257 THRU ONE WALL AS SHOWN
- ⑤ DRILL 0.189 DIA. THRU BOTH WALLS. AT 25° OFF HORIZONTAL AXIS AS SHOWN.

OPTIONAL: TEXT MAY BE ENGRAVED, STAMPED OR PRINTED ON PART AS DESIRED



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE.
WORK ORDER
NO. 34117

1	-1	1.125 O.D. : .058 TO .070 WALL	304 STAINLESS TUBING
QTY	DASH	DESCRIPTION	MATERIAL
BREAK SHARP EDGES	125	DESIGNED CLB	DATE 5/30/03
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		DRAWN	DATE
TOLERANCES ARE:		CHECKED	DATE
FRACTIONS: DECIMAL ANGLES		APPROVED GLH	DATE 5/30/03
1/16" X .005			
.001 .002			
.003 .004			
.005 .010			
THIS DOCUMENT INCLUDES INFORMATION PROPRIETARY TO GENEVA AVIATION AND SHALL NOT BE USED OR DUPLICATED BY ANYONE WITHOUT THE WRITTEN PERMISSION OF GENEVA AVIATION, INC.			Drawing Number G10202 REV A
Pro No: GA122 SIZE B Scale: 1:1 Sheet 1 of 1			

Geneva Aviation
www.GenevaAviation.com
CYCLIC STICK